

633-011

Dart Aerospace Ltd.

38

Date: Thursday, 8/30/2007 3:49:23 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	STEP WELDMENT
Job Number	34346A		
Estimate Number	10176		
P.O. Number		Part Number	D2563
This Issue	8/30/2007	Drawing Number	D2563 REV C
Prsht Rev.	NC	Project Number	N/A
First Issue	/ /	Drawing Revision	C
Previous Run	32945A	Material	
Written By		Due Date	9/21/2007 Qty: 10 Um: Each
Checked & Approved By	HJD 07.08.31		
Comment	Est Rev G 02.07.31 Re-format Location RF		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2244116	Step Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

1 D2244 Step Extrusion

Batch: BQ8216(5X)

S 33733 (51)

a 07.09.26 10

2.0	D267334	End Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part No.	Description	Batch
2	D2673-34	End Cap	332404

SL 01.09.26

10

3.0	D2561	Lug Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part No.	Description	Batch
2	D2561	Lug Plate	332403

SL 07.09.26

10

4.0	D2564	Mounting Angle
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part No.	Description	Batch
2	D2564	Mounting Angle	332400

SL 07.09.26

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 8/30/2007 3:49:24 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 34346A

Part Number: D2563

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 89.70" at 34° as per Dwg D2563

PL 07-09-26

2-Deburr ends

PL 07-09-26

3-Weld (1 End CAP,LUG PLATES & MOUNTING ANGLE as per Dwg D2563 using DT 8343

PL 07-09-27

A/R AL ROD Batch: M103794

M105058

4-Grind

AM 07.10.01

(10)

6.0 DO NOT USE

WELD INSPECTION



Comment: WELD INSPECTION

QC9  
QC5

PD 07-10-01  
E 07/10/01 (10)

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AM 07.10.01

(10)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PL 07/10/02

(10)

9.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Inspect for foreign object per QSI 024

PL 07-10-04

2-Weld Remaining End as per Dwg D2563 using DT 8343

PL 07-10-04

A/R AL ROD Batch: M103794

3-Grind

AM 07.10.09

(10)

10.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-10-09(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 8/30/2007 3:49:24 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 34346A

Part Number: D2563

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Ex 07/10/09 (10)

Comment: INSPECT WORK TO CURRENT STEP

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine then

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-f Alodine

07/10/09 (10x)

m-f

07/10/10

(10x)

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



m105694

Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2563 and QSI 005 4.4

Ex 07/10/10 (10)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/10/15 SP

(10x)

15.0 QC21

FINAL INSPECTION/W/O RELEASE



07.10.16 HJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07.10.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

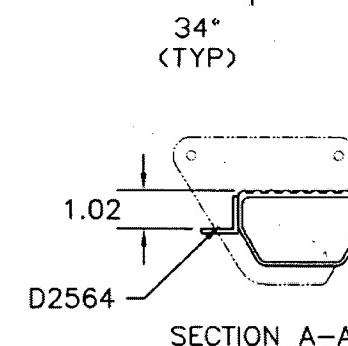
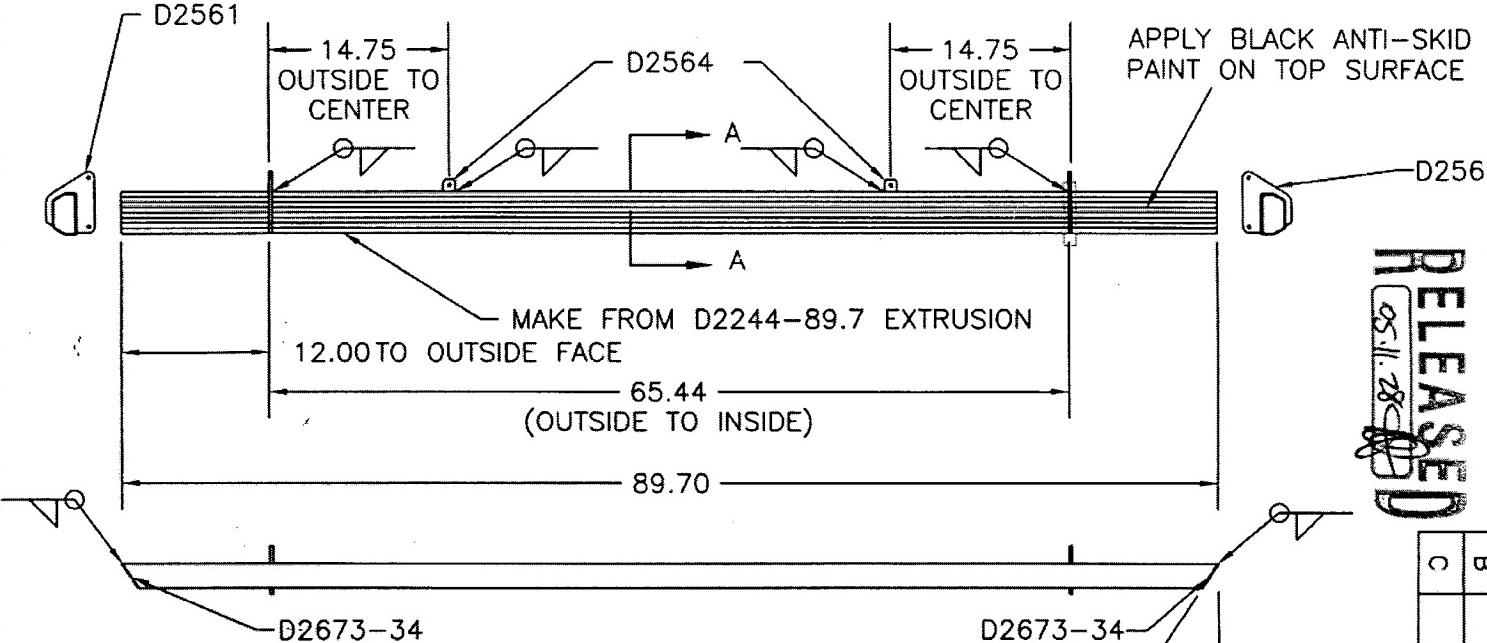
Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	STRUCTURAL MOUNTING ANGLE	2

\*cut per drawing  
No. 34320A  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

SHOP COPY  
RETURN TO  
ENGINEERING

#### D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE  
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN BY	DRAWN BY	DART AEROSPACE LTD
	PJF	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D2563
DATE		REV. C
05.11.14		SHEET 1 OF 1
A	96.04.26	TITLE
		STEP WELDMENT ASSEMBLY
B	97.05.14	SCALE
		1:15
C	05.11.14	SECTION A-A
		UPDATE NOTES

**DART**  
RE-  
05/11/28/96